

Date: Wednesday, 22/10/2008 4:08:40 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRONT RAIL, LH
Job Number : 42872	
Estimate Number : 13492	
P.O. Number :	Part Number : D37661
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D3766 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 41541	Material :
Written By :	Due Date : 07/11/2008 Qty : 10 Um : Each
Checked & Approved By : <u>JLD 08.10.22</u>	
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W



58.65



Comment: Qty.: 2.9323 f(s)/Unit Total: 29.3234 f(s)

6061T6 RD TUBE 1.00 X .188W

batch:

M104779 (4x) M109041 (6x) M-H

09/01/16

(10x)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

2-drill holes thru to finish size as per dwg D3766 using DT9413 DRILL HOLES LABELLED #1

3- deburr

FF 09/01/19

M-H

09/01/19

(P10)

(10x)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/21 (10)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/01/21

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3766-1 PAR #: N/A Fault Category: Scr / Red Fas NCR: Yes No DQA: NA Date: 09.01.26
Scrap / Scrap QA: N/C Closed: 7 Date: 09.01.27

NCR: <u>42872</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/19	#2.0	During inspection found that Section BB hole (0.257") Do not line up with D3762-3. Qty <u>(410)</u>	RA QSI 042 09.01.19	Recommend scrap b/c of poor fit and workmanship. Process of work Destroy and Replace Qty <u>(410)</u>	RA QSI 042 09/01/19	S 09/01/21	RA QSI 042 09.01.19	S 09/01/19
		RL incorrect drilling process. → Tries to drill hole 0.257" to 0.266" but will not work.		B# M104779 (8X) M109041 (2X)	M.H 09/01/20			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:08:40 PM
User: Julie Dawson

Process Sheet

3782-043

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, LH

Job Number: 42872

Part Number: D37661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-21 (K10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 247.

SS 09/01/21 (K10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/23 (K10)

Job Completion



1609.01.22

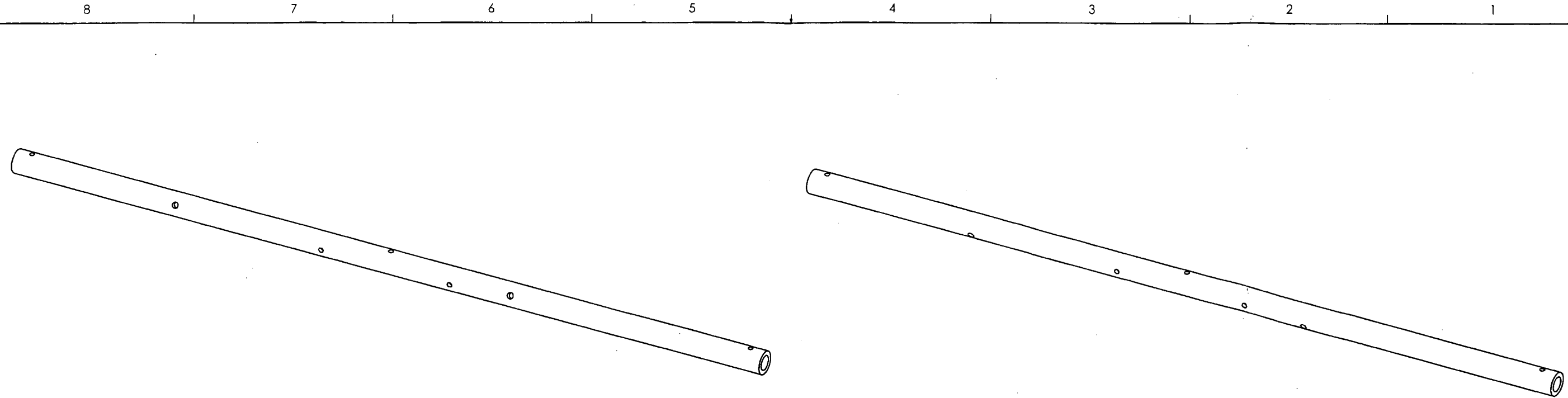
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

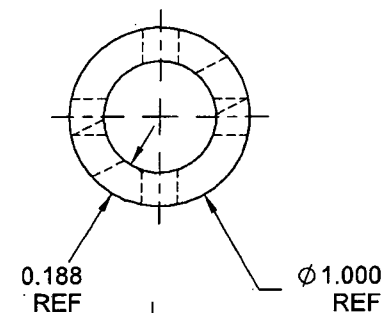
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WORK ORDER
NO 42872

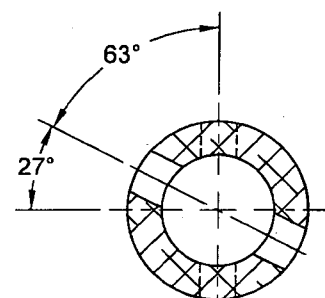
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER VW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

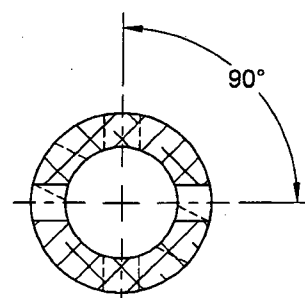
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	MA	DRAWING NO.	REV. B
MFG. APPR.	MA	D3766	SHEET 1 OF 4
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DE APPR.	MA	RAIL	NTS
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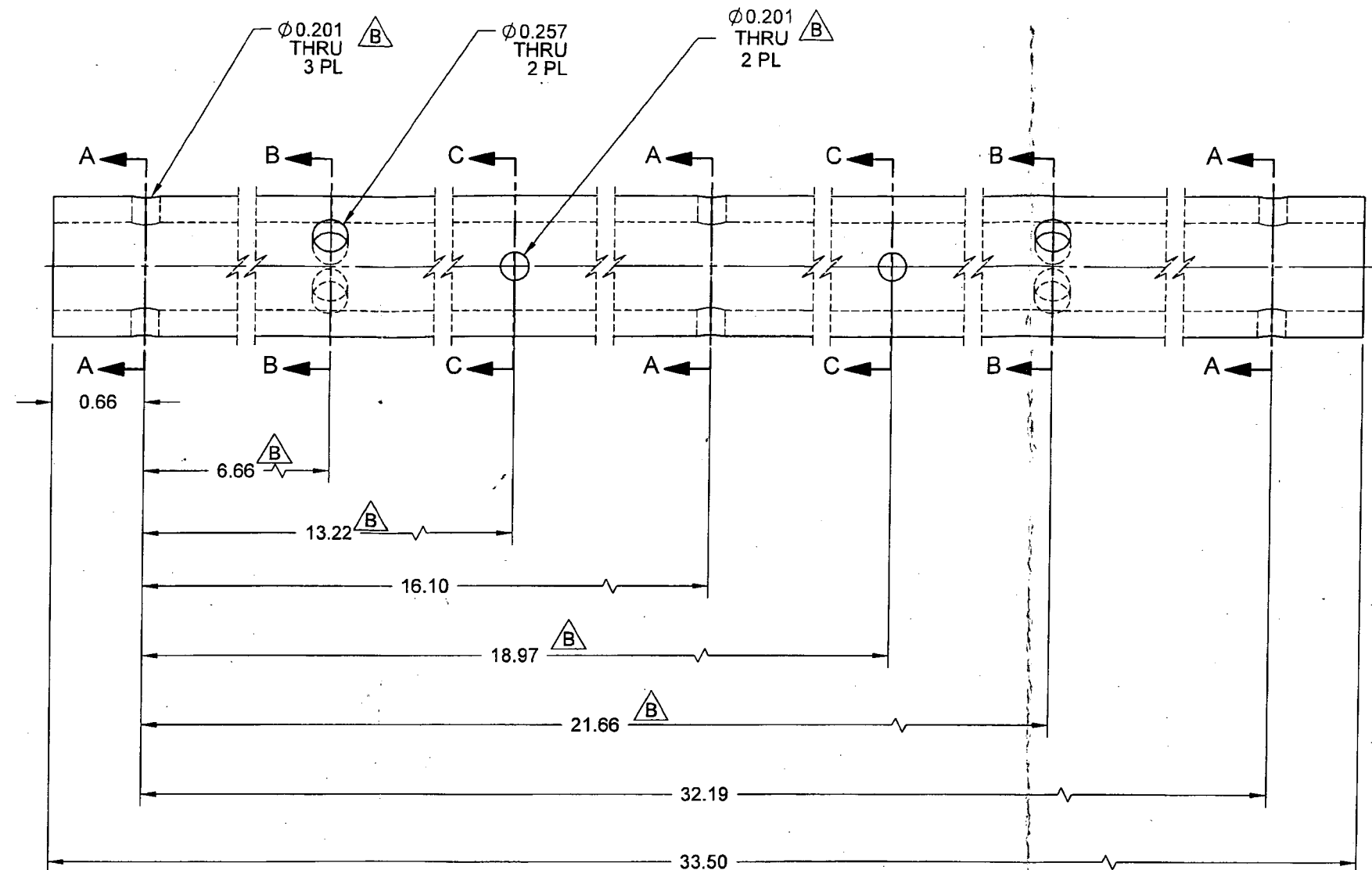
SECTION A-A



SECTION B-B



SECTION C-C

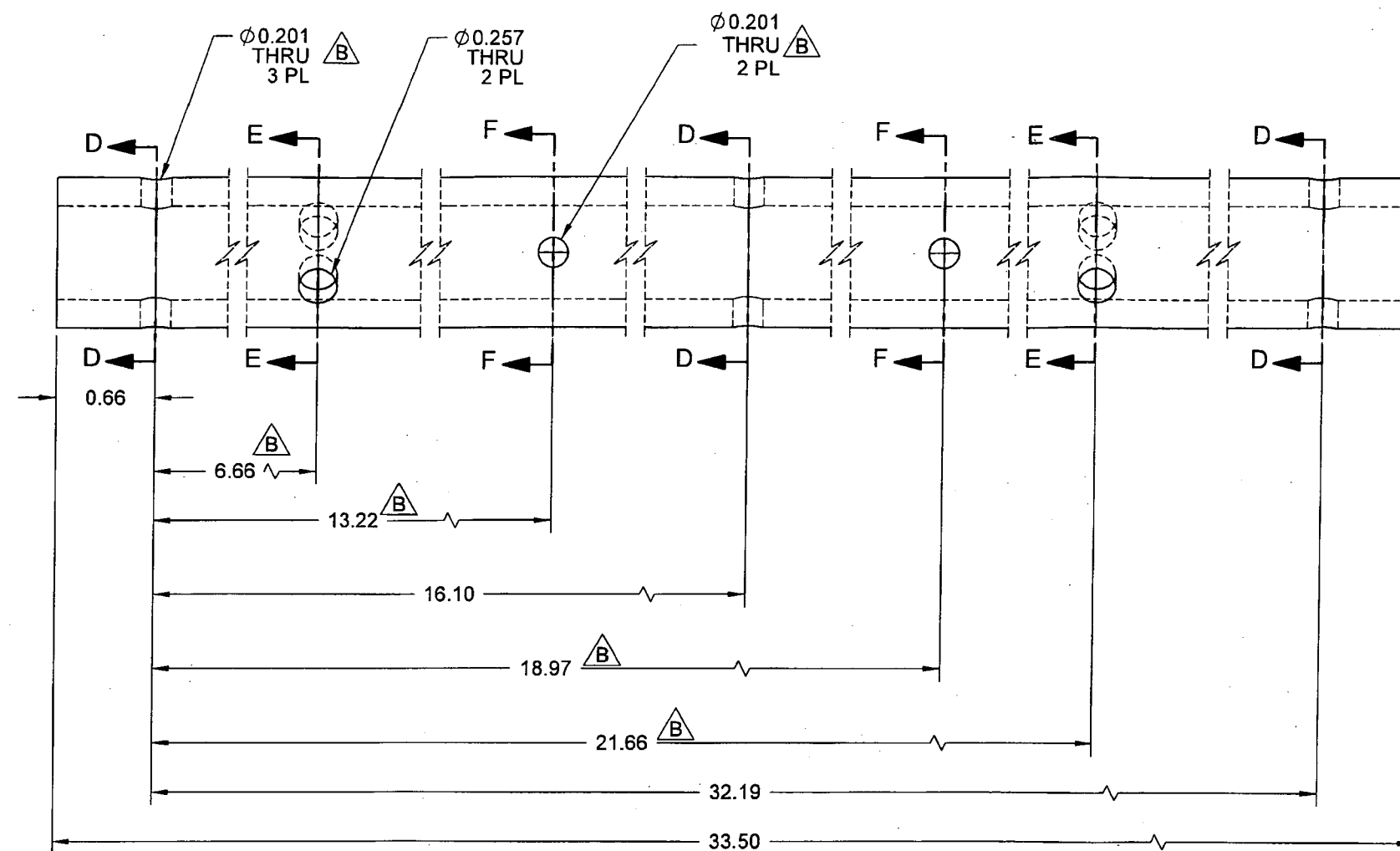
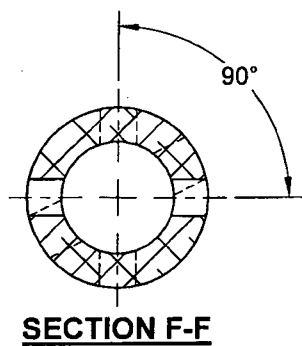
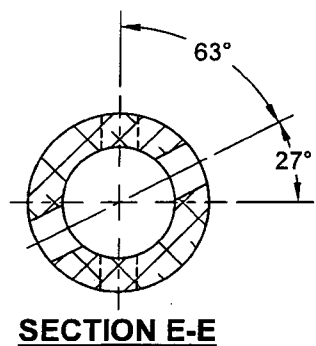
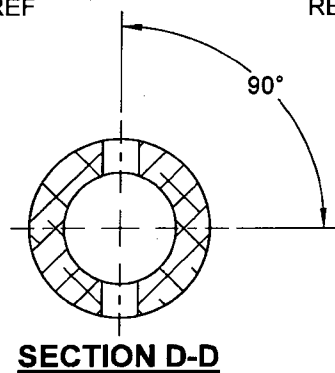
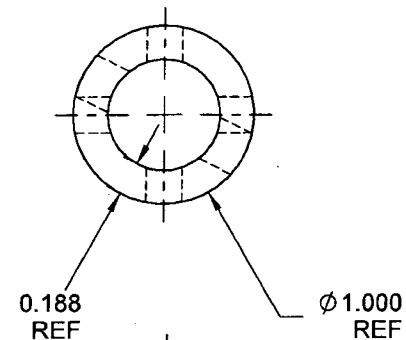


D3766-1 FRONT RAIL, LH

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D3766-2 FRONT RAIL, RH

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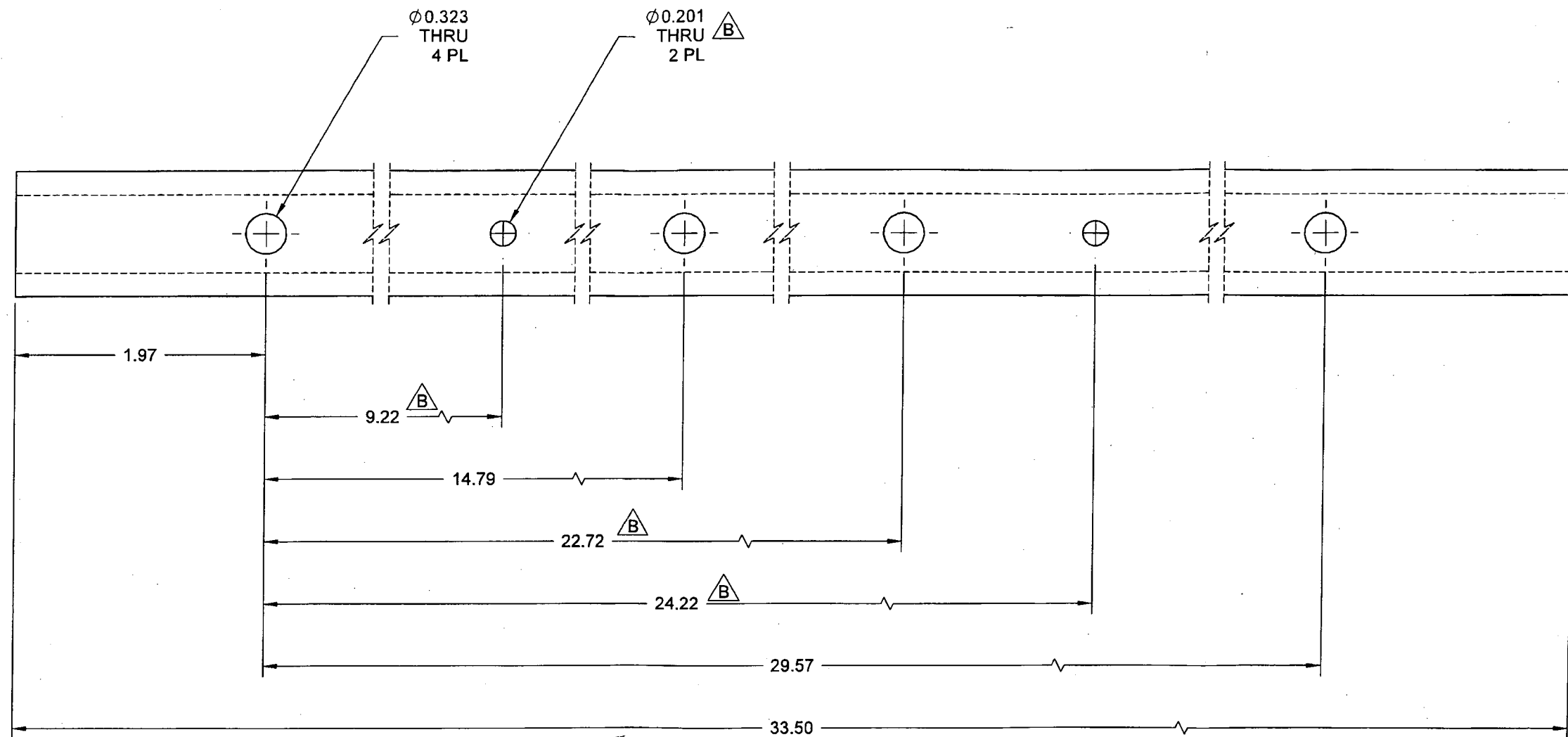
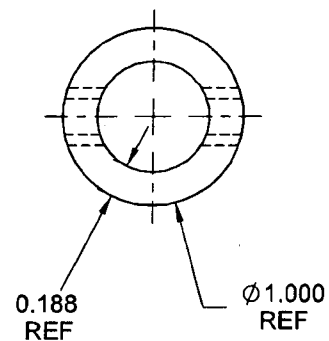
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D3766-3 REAR RAIL

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